



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D4840-041**  
**Job Sheet 178078**



Part No: D4840-041

Job Qty: 2 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 2 Ea  | 7/20/18    | 7/20/18  | 0.00      | 0.00    | Start Up Stores/Pkg-1 |           | MAY 31 2018 |
| 110   | Packaging          | 2 pcs | 7/20/18    | 7/20/18  | 0.00      | 0.00    | Packaging1-5          |           | MAY 31 2018 |
| 120   | Small Fab          | 2 pcs | 7/20/18    | 7/20/18  | 0.00      | 2.51    | Small Fab-7           |           | DAS 38      |
| 130   | QC                 | 2 pcs | 7/20/18    | 7/20/18  | 0.00      | 0.00    | QC5                   |           | JUN 05 2018 |
| 140   | Packaging          | 2 pcs | 7/20/18    | 7/20/18  | 0.00      | 0.00    | Packaging3-2          |           | DAS 9-86    |
| 150   | QC21-SA            | 2 Ea  | 7/20/18    | 7/20/18  | 0.00      | 0.00    | QC21                  |           | JUN 15 2018 |

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces. A/R LOCTITE 598: 138792 - 21 JUN 15 2018

### Job BOM

| Part / Item   | Component Name         | Quantity      | Operation             | Container |
|---------------|------------------------|---------------|-----------------------|-----------|
| D4823-1       | Upper Cutter Deflector | 2 Ea (1 ea)   | 90-Start up Operation | 5082460   |
| D4824-1       | Upper Cutter Mount     | 2 Ea (1 ea)   | 90-Start up Operation | 5015992   |
| D4838-1       | Upper Cutter Body, LH  | 2 Ea (1 ea)   | 90-Start up Operation | 5025887   |
| D4838-2       | Upper Cutter Body, RH  | 2 Ea (1 ea)   | 90-Start up Operation | 5025873   |
| D4839-1       | Blade                  | 4 Ea (2 ea)   | 90-Start up Operation | 5075892   |
| MS21042L08    | Nut                    | 28 Ea (14 ea) | 90-Start up Operation | 5014235   |
| MS27039-08-19 | Screw                  | 28 Ea (14 ea) | 90-Start up Operation | 5014235   |
| NAS1149FN832P | Washer                 | 56 Ea (28 ea) | 90-Start up Operation | 5020604   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D4823-1        | 2        | 6         | 0         |
|                       | D4824-1        | 2        | 9         | 0         |
|                       | D4838-1        | 2        | 17        | 0         |
|                       | D4838-2        | 2        | 15        | 0         |
|                       | D4839-1        | 4        | 2         | 0         |
|                       | MS21042L08     | 28       | 1,762     | 0         |
|                       | MS27039-08-19  | 28       | 1,299     | 0         |
|                       | NAS1149FN832P  | 56       | 1,959     | 0         |

### Part Specifications

3527 Specifications could not be found.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                   |  |
|--------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |  |                                                   |  |
| Date :                                                       | Step #:                                                                                                                                                                            | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  | MRB (QSI042) Approval                             |  |
| Description Work Order Deviation                             |                                                                                                                                                                                    | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | Completed By<br><br><br>/ Supervisor Verification |  |
|                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                   |  |

Job No: 178078  
 Mfg Date: 05/31/18

PART NO: D4840-041  
 Serial No/Batch: S076797  
 Revision:  
 Operation:  
 Change No:

Packaging

| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                      |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | Pressure/Fc <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/><br>OTHER : <input type="checkbox"/> |

ned Wrong  
 e Dimensions  
 Under tolerance  
 incorrect  
 cost/Missing  
 Moved  
 ng  
  
 ad  
 Missing Sequence





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## Container View (Active) - Master Unit Containers

| Master Unit No | Container No | Part No       | Part Name              | From Container | Current Location | Quantity |
|----------------|--------------|---------------|------------------------|----------------|------------------|----------|
| 003567         | S076777      | D4823-1       | Upper Cutter Deflector | S052460        | CCK036           | 2        |
| 003567         | S076778      | D4824-1       | Upper Cutter Mount     | S015992        | CCK036           | 2        |
| 003567         | S076780      | D4838-1       | Upper Cutter Body, LH  | S025187        | CCK128           | 2        |
| 003567         | S076782      | D4838-2       | Upper Cutter Body, RH  | S025273        | CCK128           | 2        |
| 003567         | S076792      | D4839-1       | Blade                  | S075982        | CCK128           | 4        |
| 003567         | S076793      | MS21042L08    | Nut                    | S044234        | ST303            | 28       |
| 003567         | S076794      | MS27039-08-19 | Screw                  | S044235        | ST277            | 28       |
| 003567         | S076795      | NAS1149FN832P | Washer                 | S020604        | ST263            | 56       |

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 5/31/18 11:20 AM dart.quirion.sonia